



Dart Aerospace Ltd.
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RBE703A94-1130-01-01
Job Sheet 193097



350 MH

Part No: RBE703A94-1130-01-01

Job Qty: 6 pcs

Part Name: Immobilizing Clip Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/8/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE703A94-1130-01 Rev K IPP Rev.A 17.08.08 New issue DP Verify DD/IPP Rev B 17.11.30 DWG Rev K DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Small Fab - 1	20 pcs	5/6/19	5/6/19	0.00	20.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
130	QC 5	20 pcs	5/6/19	5/6/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
140	Packaging 3-1 - Stock - B4B	20 pcs	5/6/19	5/6/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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Container No: S187057



Part: RBE703A94-1130-01-01

Job No: 193097

Serial No/Batch: S187057

Revision: K

Inspector:

Exp Date:

Instructions:

Date: 06/04/19

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					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	Dara
150 QC 21 - SA	20 pcs	5/6/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

GA 133

Part Op 120 - (Small Fab) Assemble as per DWG. Sheet 2
 Descriptions: 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Identify as per dwg & Stock Location: _____)
 150 - (QC21- Final Inspection - Work Order Release)

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JUN 05 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90353A217	Pan Head Machine Screw M4 x 0.7mm x 20mm	1240 Ea (2 ea)	120-Small Fab - 1	FM138919-5
91166A270	Washer, M8	2480 Ea (4 ea)	120-Small Fab - 1	FM138914-10
91595A112	Dowel Pin ØM3 x 12mm	1240 Ea (2 ea)	120-Small Fab - 1	5122134
98296A881	Roll Pin Ø1/8 X 3/4	1240 Ea (2 ea)	120-Small Fab - 1	FM138916-33
RBE703A94-1130-01-03	Bottom Fixture 1	620 pcs (1 ea)	120-Small Fab - 1	KS126190 5X5168308
RBE703A94-1130-01-05	Fixture Handle	1240 pcs (2 ea)	120-Small Fab - 1	KS126190 5X5168308
RBE703A94-1130-01-07	Handle Stud	1240 pcs (2 ea)	120-Small Fab - 1	KS126190 5X5168308
RBE703A94-1130-01-09	Bottom Fixture 2	620 pcs (1 ea)	120-Small Fab - 1	KS126190 5X5168308
RBE703A94-1130-01-11	Angle Indicator	620 pcs (1 ea)	120-Small Fab - 1	KS126190 5X5168308
RBE703A94-1130-01-13	Compression Spring Ø1.25mm x 11.25mm OD x 44.5mm	40 pcs (2 ea)	120-Small Fab - 1	KS126190 5X5168308

3X5126692

392

720

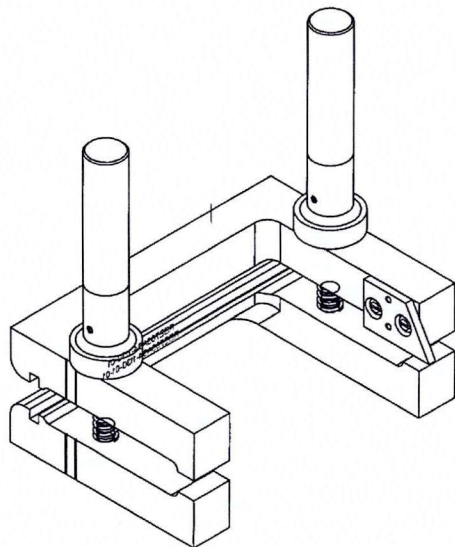
86

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Small Fab - 1	90353A217	40	23	0
	91166A270	80	139	0
	91595A112	40	105	0
	98296A881	40	173	0
	RBE703A94-1130-01-03	20	11	0
	RBE703A94-1130-01-05	40	19	0
	RBE703A94-1130-01-07	40	16	0
	RBE703A94-1130-01-09	20	6	0
	RBE703A94-1130-01-11	20	7	0
	RBE703A94-1130-01-13	40	12	0
Part Specifications				
Specifications could not be found.				

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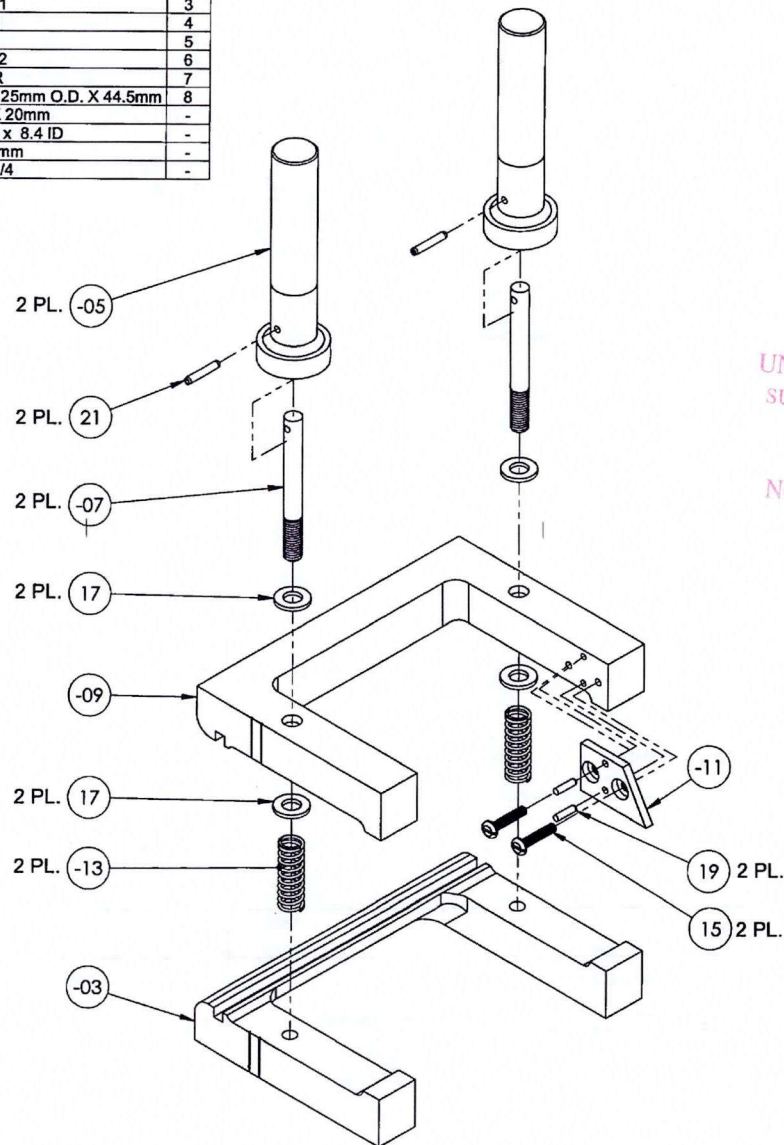
ITEM #	QTY	PART #	TITLE	PG
-03	1	RBE703A94-1130-01-03	BOTTOM FIXTURE 1	3
-05	2	RBE703A94-1130-01-05	FIXTURE HANDLE	4
-07	2	RBE703A94-1130-01-07	HANDLE STUD	5
-09	1	RBE703A94-1130-01-09	BOTTOM FIXTURE 2	6
-11	1	RBE703A94-1130-01-11	ANGLE INDICATOR	7
-13	2	RBE703A94-1130-01-13	COMPRESSION SPRING Ø1.25mm X 11.25mm O.D. X 44.5mm	8
15	2	McMaster#90353A217	PAN HEAD M4 X 0.7mm X 20mm	-
17	4	McMaster#91166A270	FLAT WASHER M8 x 16 OD x 8.4 ID	-
19	2	McMaster#91595A112	DOWEL PIN ØM3 X 12mm	-
21	2	McMaster#98296A881	SPRING PIN Ø1/8 X 3/4	-



RBE703A94-1130-01-01 IMMOBILIZING CLIP ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A



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WORK ORDER

NO. 193074 415
1904-08

DART AEROSPACE Hawksbury, Ontario, Canada			
IMMOBILIZING CLIP ASSY			
TITLE IMMOBILIZING CLIP ASSY		REV K	
CWS NO. RBE703A94-1130-01-01			
DESIGN BY: VM 9/8/2017	CHECKED: WM 11/24/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
DRAWN BY: VM 11/24/2017	APPROVED: WM 11/30/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE: 11/24/2017	SCALE: NTS	WEIGHT: N/A	SHEET 2 OF 17
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					